



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3255
Job Sheet 205323



Part No: D3255

Job Qty: 50 sf

DAS

21

Part Name: Gasket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/7/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 2/7/20

Description:

Type: Stock

Note: DWG REV B IPP A 04.04.06 New issue KJ/RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing - SF	50 sf		2/7/20	0.00	0.00	Purchasing - 1	
	JAN 10 2020						Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	50 pcs		2/7/20	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S247293



Part: D3255

Job No: 205323

Serial No/Batch: S247293

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/14/20

1/7/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
120 QC 6	50 pcs	2/7/20	0.00 0.00	QC 6 - 9	DAS 40 9-89
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	JAN 14 2020
				QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	50 pcs	2/7/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS 28 9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA SF	50 sf	2/7/20	0.00 0.00	QC 21 - SA - 21	WJ-CABINET
				QC 21 - SA - 70	DAS 21 9-89
				QC 21 - SA - 53	JAN 16 2020
Part Op 100 - (Purchasing) Issue P/O: _____ Possible Supplier: Mc Master Carr P/N: 8612K61 Material: Silicone coated Descriptions: fiberglass cloth per AMS 3320F SIL/36' x 36' x 1/16" Certificat of conformaty required 110 - Ensure Material Release Note is attached 120 - (QC6- All purchased or subcontracted products) 130 - (Identify as per dwg & Stock Location: _____) WJ - CABINET 140 - (QC21- Final Inspection - Work Order Release)					

Plex 1/7/20 2:46 PM Dart.lajeunesse.marie

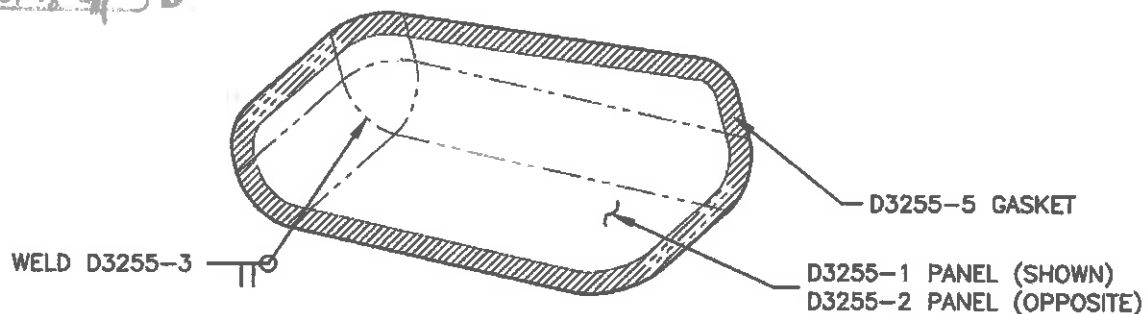
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
SIL/F36X36X1/16	Gasket	50 sf (1 ea)	100-Purchasing - SF	5247290
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing - SF	SIL/F36X36X1/16	50	0	0
Part Specifications				
Specifications could not be found.				

Plex 1/7/20 2:46 PM Dart.lajeunesse.marie

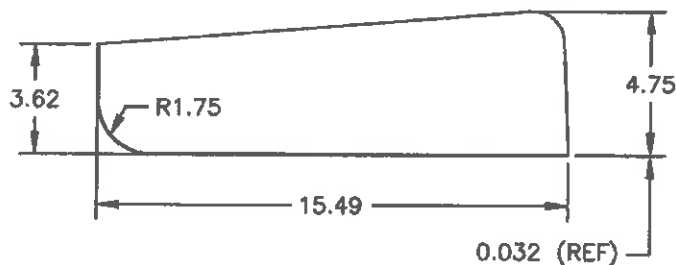
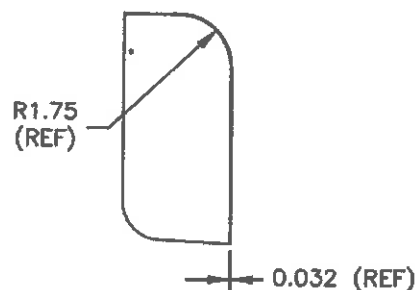
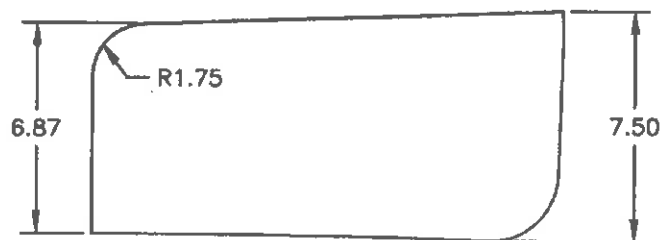


DESIGN F#	DRAWN BY F#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 4P	APPROVED F#	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED
05-01-18



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 205323 MJS
2001-08

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

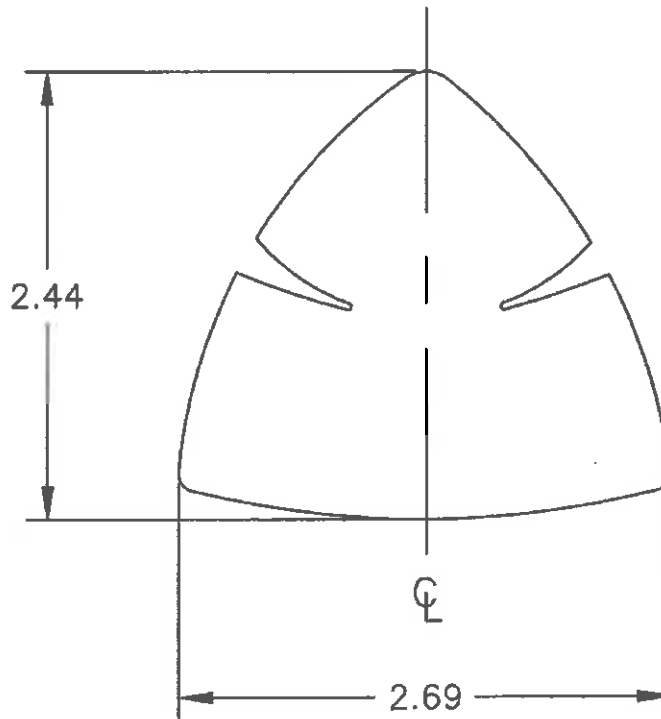
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DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05.01.18



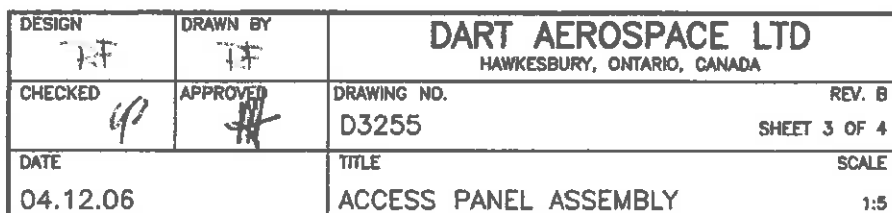
D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

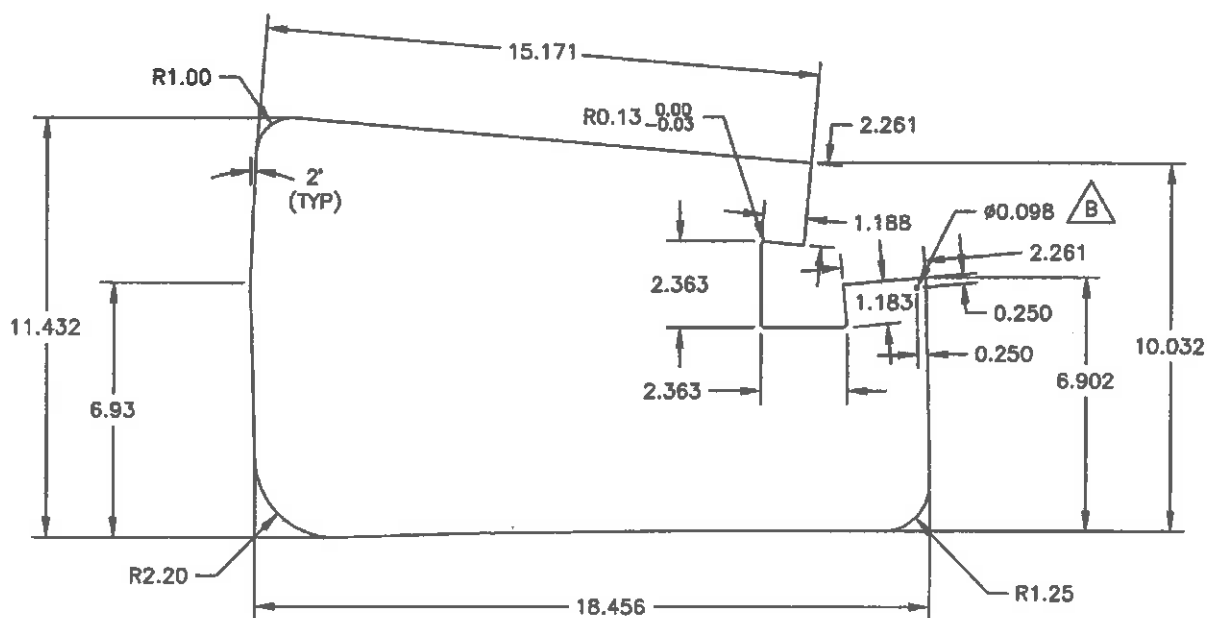
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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RELEASED
05-01-18



D3255-1/-2 NOTES:

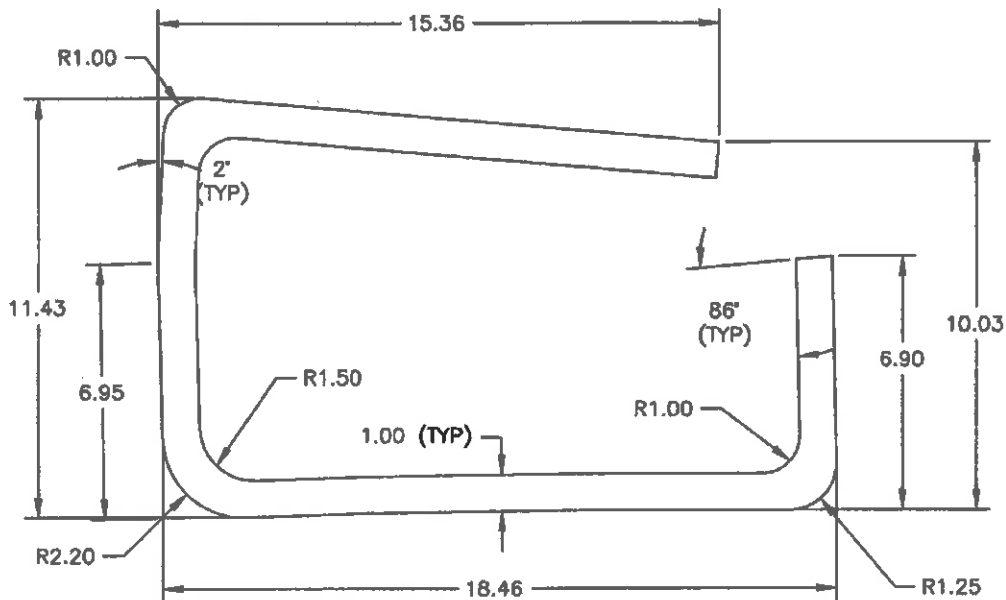
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART

DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05 01.18 JF**D3255-5 GASKET****D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐ ☐				Date : _____ Sequence #: _____ QTY Affected : _____		MRB (QS1042) _____	
Description Work Order Deviation				Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY							
				Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
				Other/Details: _____							
Completed By _____				Lead hand / Supervisor _____							
QC / QA Coordinator _____				_____							



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB045533



Supplier: MCM001-VU
McMaster-Carr Supply Co,
P.O. Box 7690
Chicago, IL 60680-7690 USA
Phone: 330 995 5500
Fax: 330 995 9600

Attention: N/A,

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045533

PO Date: 1/10/20

Due Date: 1/17/20

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

JAN 10 2020

Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1		16823		85195A999	Giant Swiss Arm w/o Mag. Base	Firmed	-	1/23/20	1 Ea	0 Ea	1 Ea	\$435.76/Ea	\$435.76
2		3495T51		1/pk	Heavy Duty Wire Rope Thimble - for Lifting, 18-8 Stainless Steel, for 5/8" Rope Diameter	Firmed	-	1/17/20	4 Ea	0 Ea	4 Ea	\$15.90/Ea	\$63.60
3	205201	5462K62		1/pk	Supra Heavy Duty Hose Clamp Stainless Steel, W4 79-85 D5616-3 : AS PER DWG D5616 REV. B	Firmed	-	1/17/20	20 Ea	0 Ea	20 Ea	\$12.34/Ea	\$246.80
4		601.2045		6641A41	RTV (LOCTITE 598) : RTV, Loctite 598 EXP: DATE REQUIRED AT 6 MONTH SELF LIFE	Firmed	-	1/17/20	8 Ea	0 Ea	8 Ea	\$14.36/Ea	\$114.88
5	205228	6264K72		1/pk	Half Link D5039-5 : AS PER DWG D5039 REV. B	Firmed	-	1/17/20	4 pcs	0 pcs	4 pcs	\$7.80/pcs	\$31.20

Plex 1/10/20 9:17 AM Dart.Lavoie.Chantal



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-6200

PURCHASE ORDER POHB045533



Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
6	205096	63215K34	D2611 REV. C		Bearing (D2611) : AS PER DWG D2611 rev. C	Firmed	-	1/17/20	40 Ea	0 Ea	40 Ea	\$17.24/Ea	\$689.60
						X40		JAN 13 2020				OP	
7	204882	6605K56		5/pk	Hook And Loop Tie D3551-11 : AS PER DWG D3551 REV.A	Firmed	-	1/17/20	10 pcs	0 pcs	10 pcs	\$3.09/pcs	\$30.90
						X10		JAN 13 2020				OP	
8	205215	6L094		6264k52 1/PK	Master Link D5039-3 : AS PER D5039 REV.B	Firmed	-	1/17/20	24 Ea	0 Ea	24 Ea	\$3.46/Ea	\$83.04
						X24		JAN 14 2020				OP	
9		8183K6		1/pk	Wire Guide/Grip	Firmed	-	1/17/20	4 Ea	0 Ea	4 Ea	\$9.83/Ea	\$39.32
						X4		JAN 14 2020				OP	
10	205431	D6209P		1630T14 / 1630T35 5 FT	U-Channel Extrusion : Various STC's	Firmed	-	1/17/20	5 ft	0 ft	5 ft	\$16.026/ft	\$80.13
11	205323	SIL/F36X36X1/16		8612K61	Gasket receive sf	Firmed	-	1/17/20	30 sf	0 sf	60 sf	\$9.0183333/sf	\$541.10
						X30sf		JAN 14 2020				OP	
Line Item Note 5 pcs = 60 sf													
12	204889	6519T14		10 ft length/pcs	Tubing D5528-1 : AS PER DWG D5528 REV. A PCS OF 10 FT LONG REQUIRED	Firmed	-	1/17/20	20 Ea	0 Ea	20 Ea	\$50.70/Ea	\$1,014.00
						X20		JAN 13 2020				OP	
Line Item Note 20 pcs cut to 10 ft length													
												Grand Total:	\$3,370.33

CDP



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB045533



Order Notes

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A016 PERSONNEL QUALIFICATION

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A032 DOCUMENT SPECIAL REQUIREMENTS

A033 STATEMENT OF CONFORMITY/TEST RECORDS FOR NAS, AN and MS FASTENERS

A040 NOTIFICATION OF QUALITY ESCAPE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENTS

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/10/20 9:17 AM Dart.Lavoie.Chantal

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: N/A

Purchase Order
POHB045533

Order Placed By
Chantal Lavoie

McMaster-Carr Number
7433523-02

Page 1 of 1

01/10/2020

Line	Product	Ordered	Shipped
10	8612K61 Fabric-Reinforced Silicone Rubber Sheet, High-Temperature, 24" x 36", 1/16" Thick	5 Each	5

Expected to ship

1	85195A999 Giant Swiss Arm Only, 19" Total Height, #16823	1 Each	1 Jan 17-23
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Certificate of compliance

This is to certify that the above items were supplied in accordance with the description and as illustrated in the catalog. Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department.



Sarah Weinberg
Compliance Manager

RECEIVED

JAN 13 2020

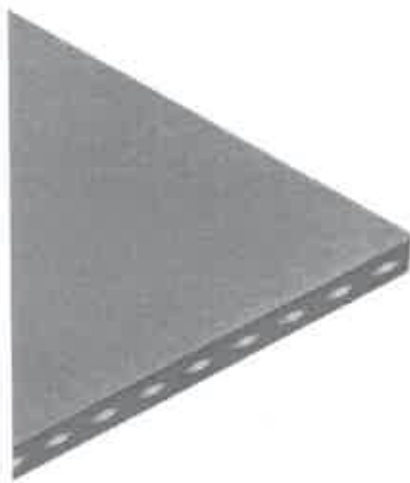
DART AEROSPACE LTD.



Fabric-Reinforced Silicone Rubber Sheet

High-Temperature, 24" x 36", 1/16" Thick

\$108.22 Each
8612K61



Material	Silicone
Shape	Sheet and Bar
Texture	Smooth
Thickness	1/16"
Thickness Tolerance	-0.012" to +0.012"
Width	24"
Width Tolerance	+1.000"
Length	36"
Length Tolerance	+1"
Backing Type	Plain
For Use Outdoors	Yes
Temperature Range	-100° to 500° F
Tensile Strength	1,300 psi
Color	Red
Reinforcement Material	Fiberglass Fabric
Durometer	70A (Hard)
Durometer Tolerance	-10 to +10
Specifications Met	AMS 3320H, Made of FDA-Listed Material for Use with Food and Beverage
REACH	Not Compliant

DAS
82
9-89

One layer of fiberglass cloth is inserted between two layers of silicone rubber to give these sheets and strips the strength to stand up to high stress and flex. Use them as flange gaskets and anywhere heavy compression would squeeze nonreinforced silicone rubber out of place. Silicone, commonly called polysiloxane, offers good resistance to ozone and salt water.